

ASAP !!!

# Work Order ID 54844

December 29, 2009 9:11:07 AM



Item ID: D3294-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket

Start Date: 12/30/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 1/13/2010 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: MF

Date: 09-12-29

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3294

Rev C

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3294

Dwg Rev: C

Prog Rev: C

\*grain direction on a 45 deg as per dwg\*\*

2-Deburr if necessary

B 10-1-5

11

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B 10-1-5

W/O: 54844

## WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/01/05 <del>10/01/05</del>	120	Took qty +1 Part for QC inspection template.	E	10/01/05	+1		 10/01/05

Part No: D3294-1 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Required Date: 1/13/2010 Req'd Qty: 10.00

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Approvals: Process Plan: Date: Tooling: Date:

QC: Date: SPC (Y/N): Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

0.00

Hand Finishing

160

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

170

0.00

Small Fab

Memo

0.00

Small Fab

1-Install D3294-5 doubler to D3294-3 bracket with rivets as per dwg. D3294

10-01-06 10

10-01-06 X10

12/30/09 10

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Customer:

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Run Start



Approvals:

Process Plan:

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Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

=> S 10/2/01

(410)

Memo

0.00

190



Powdercoat

Powder Coating

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

11 105642

0.00

=> JH 10/02/02

(X10) ✓

Memo

0.00

Start Time: 1:30pm  
Oven Temperature: 320°-  
Finish Time: 2:00pm

200



QC

Quality Control

QC3- Inspect Part Finish

0.00

BK 10-02-02

(10) ✓

Memo

0.00

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Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

210

Identify as per dwg &amp; Stock Location

0.00



Packaging

Memo

0.00

Packaging

10-2-3 100 SF

220

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/02/04

MF 10-2-4

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# Picklist Print

December 29, 2009 9:11:07 AM

Page 1

Work Order ID: 54844

Parent Item: D3294-1

Parent Item Name: Bracket

Comments:

Start Date: 12/30/2009

Required Date: 1/13/2010

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M2024T3S.080		Purchased	No			100	sf	169.2618	18.9474	21.		
2024-T3 .080 sheet												

Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

MAT

169.26185

104921

3

105411

17

107460

4.36

110908

29.52205

112331

105.8798

15628

6

17695

1.5

18481

2

D3294-5

Manufactured

No

170

Each

22.0000

10.0000

Doubler

Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

ST

22

47418

8

50694

14

11

13 10-1-5

112331

8/5/10/01/29

8

B55331 (2x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

Page 2

December 29, 2009 9:11:07 AM

Work Order ID: 54844



Parent Item: D3294-1



Parent Item Name: Bracket

Start Date: 12/30/2009

Required Date: 1/13/2010

Comments:

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

MS20470AD4-5

Purchased

No

170

Each

2,485.000

150.0000



Rivet, Universal Head

*Handwritten signature and date: 12/30/09*

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

2485

109031

6

111916

2479

150

December 29, 2009 9:11:07 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 54844
<b>Description:</b> Bracket Assembly		<b>Part Number:</b> D3294-1
<b>Inspection Dwg:</b> D3294	<b>Rev:</b> C	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	.131	x			
Ø0.141	+0.005/-0.001	.144	x			
6.708	+/-0.010	6.707	x			
1.118	+/-0.010	1.117	x			
5.590	+/-0.010	5.591	x			
1.118	+/-0.010	1.118	x			
13.563	+/-0.010	13.563	x			
1.043	+/-0.010	1.043	x			
0.625	+/-0.010	.627	x			
0.325	+/-0.010	.324	x			
0.300	+/-0.010	.296	x			
0.400	+/-0.010	.400	x			
6.000	+/-0.010	5.998	x			
1.000	+/-0.010	.998	x			
17.124	+/-0.010	17.125	x			
16.13	+/-0.030	16.125	x			
7.27	+/-0.030	7.276	x			
11.97	+/-0.030	11.958	x			
8.37	+/-0.030	8.368	x			
20.05	+/-0.030	20.05	x			
12.98	+/-0.030	12.98	x			
14.59	+/-0.030	14.59	x			
11.66	+/-0.030	11.66	x			
0.080	+/-0.010	.079	x			

<b>Measured by:</b> IB	<b>Audited by:</b> S	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 10-1-5	<b>Date:</b> 10/01/05	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	04.08.24	New Issue	KJ/JLM	
B	06.03.09	Dimension 12.97 was 13.03	KJ/JLM	
C	08.11.27	Dimensions updated per Dwg Rev B	KJ/EC	
D	09.07.29	Dimension 2.100 was 2.072	KJ	
E	09.09.14	Dimensions updated per Dwg Rev C	KJ	

W/O:		WORK ORDER CHANGES					
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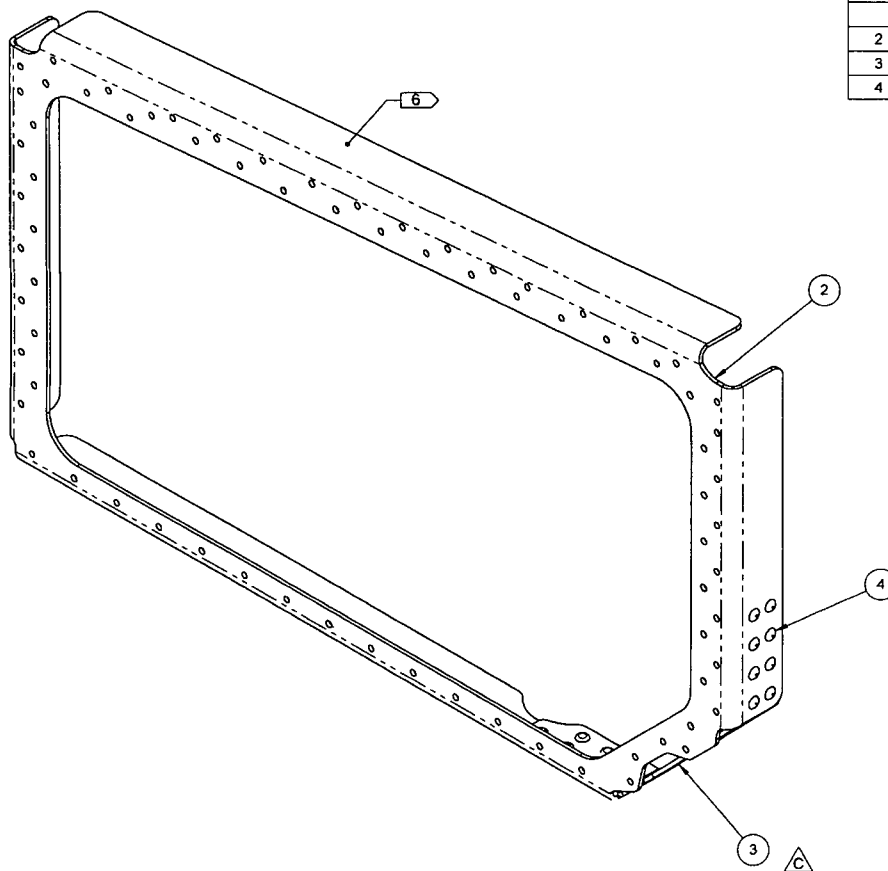
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ITEM NO.	QTY. -1	PART NUMBER	DESCRIPTION
1	X	D3294-1	BRACKET ASSEMBLY
2	1	D3294-3	BRACKET
3	1	D3294-5	DOUBLER
4	15	MS20470AD4-5	RIVET



**D3294-1 BRACKET ASSEMBLY**

- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: POWDER COAT "BLACK" (4.3.5.7) PER DART QSI 005 4.3
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3294-1 AND B/N" USING FINE POINT PERMANENT INK MARKER
  - 7) WEIGHT: 0.83 lbs

REV.	DESCRIPTION	BY	DATE
C	REMOVE FLANGE PREVIOUSLY ADDED. ADD -5 DOUBLER ZN A4-1, SHEET 5+6.	HS	09.03.24
B	CHANGE FLANGE FROM OUTSIDE TO INSIDE, ZN B4-1, C3-2. CHANGE GRAIN DIRECTION, ZN C4-2	HS	08.09.22
A	NEW ISSUE	CP	04.06.28
DESIGN	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	DRAWING NO. D3294		
CHECKED	REV. C		
MFG. APPR.	SHEET 1 OF 6		
APPROVED	TITLE		
DE APPR.	BRACKET		
DATE	09.03.24		

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**RELEASED**  
09/03/24

# 54844

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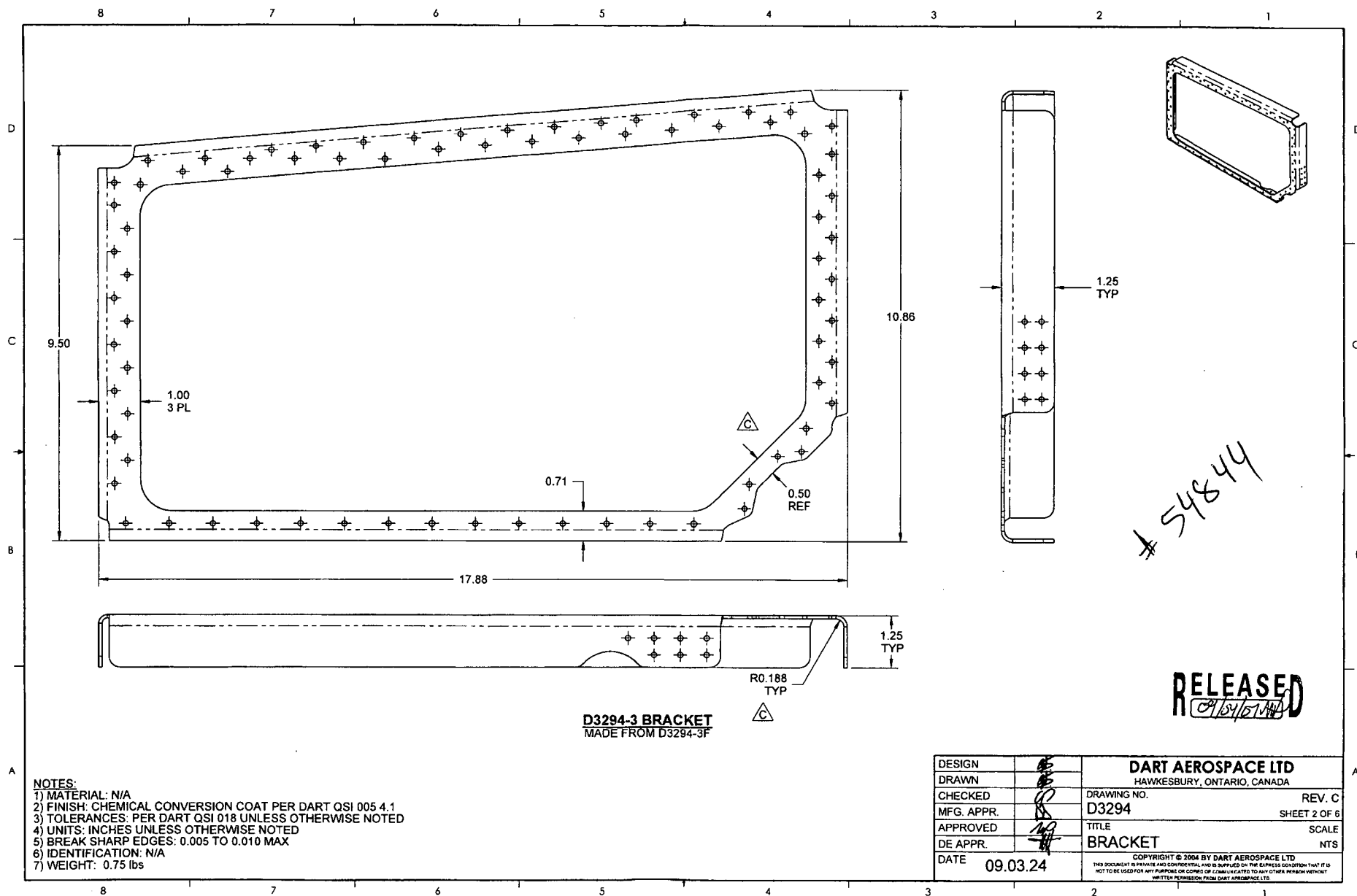
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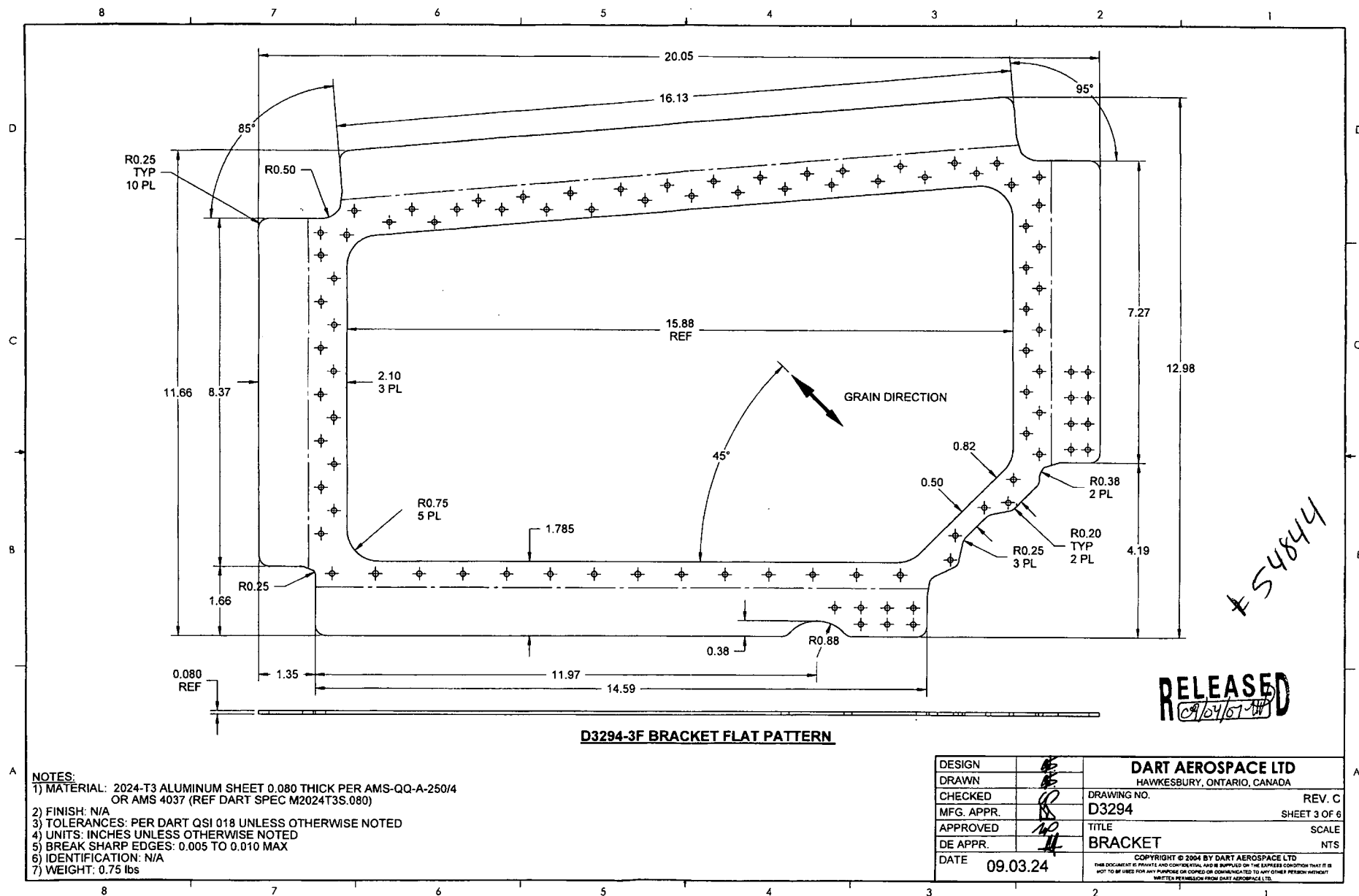
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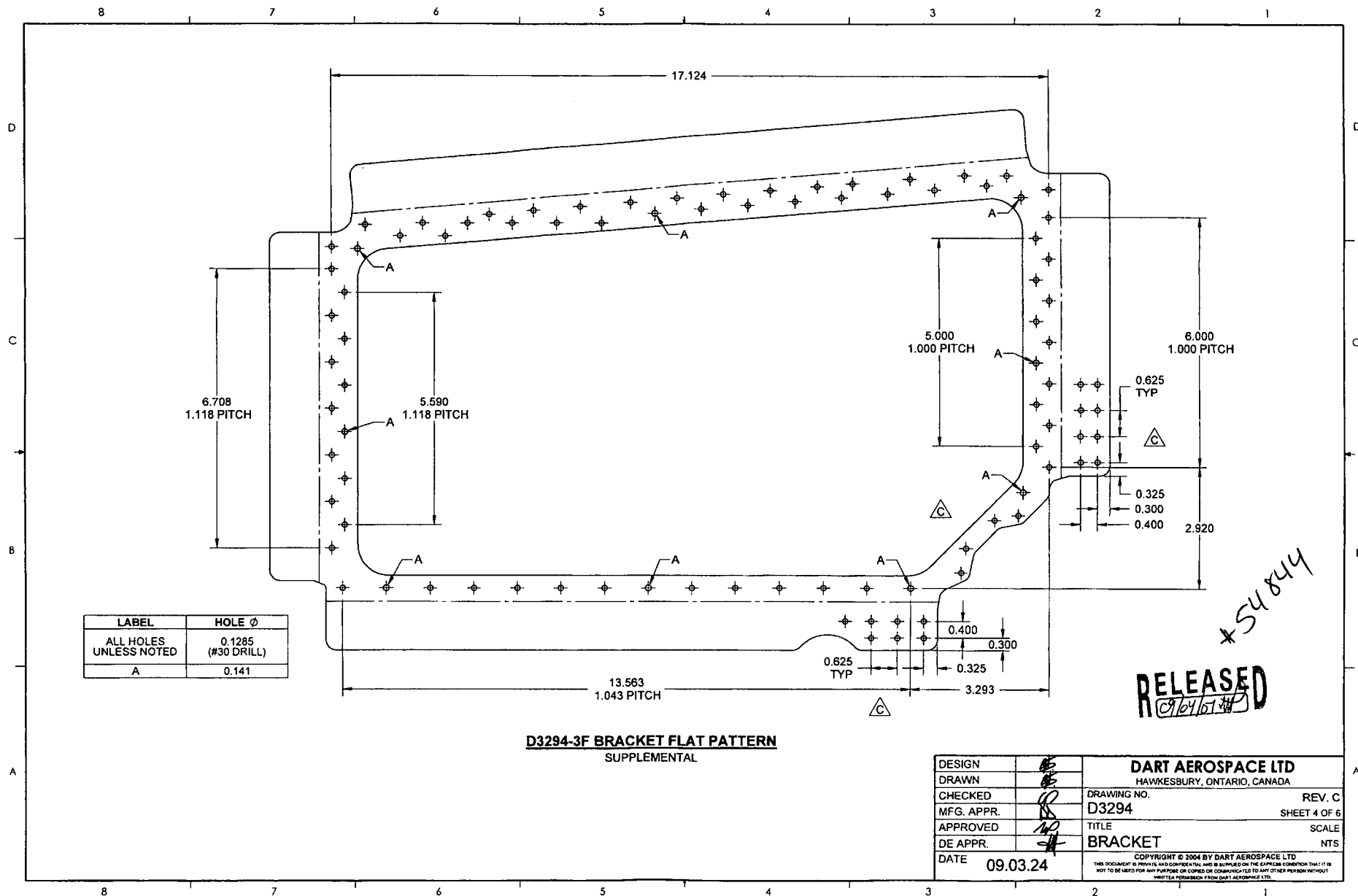
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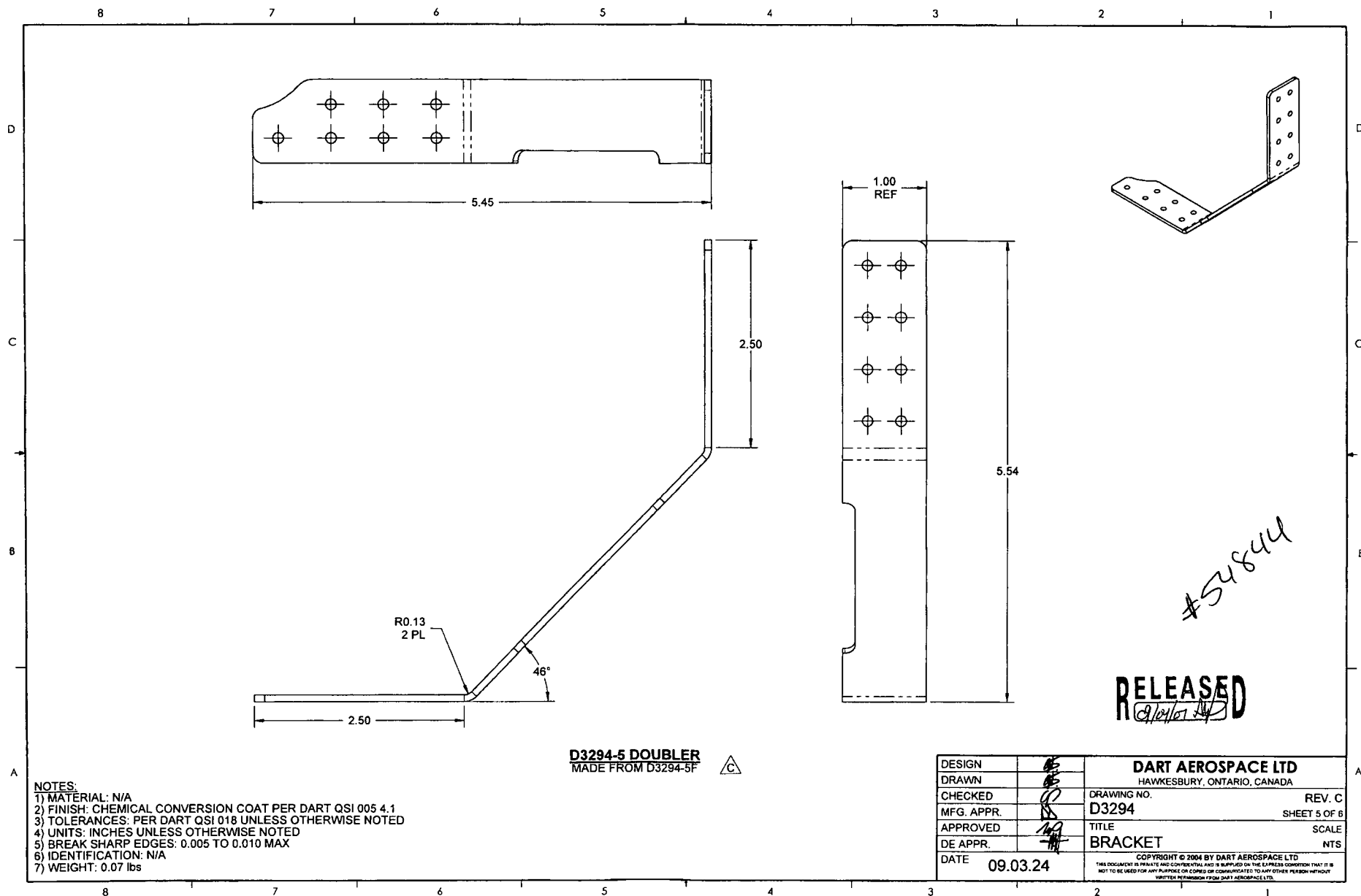
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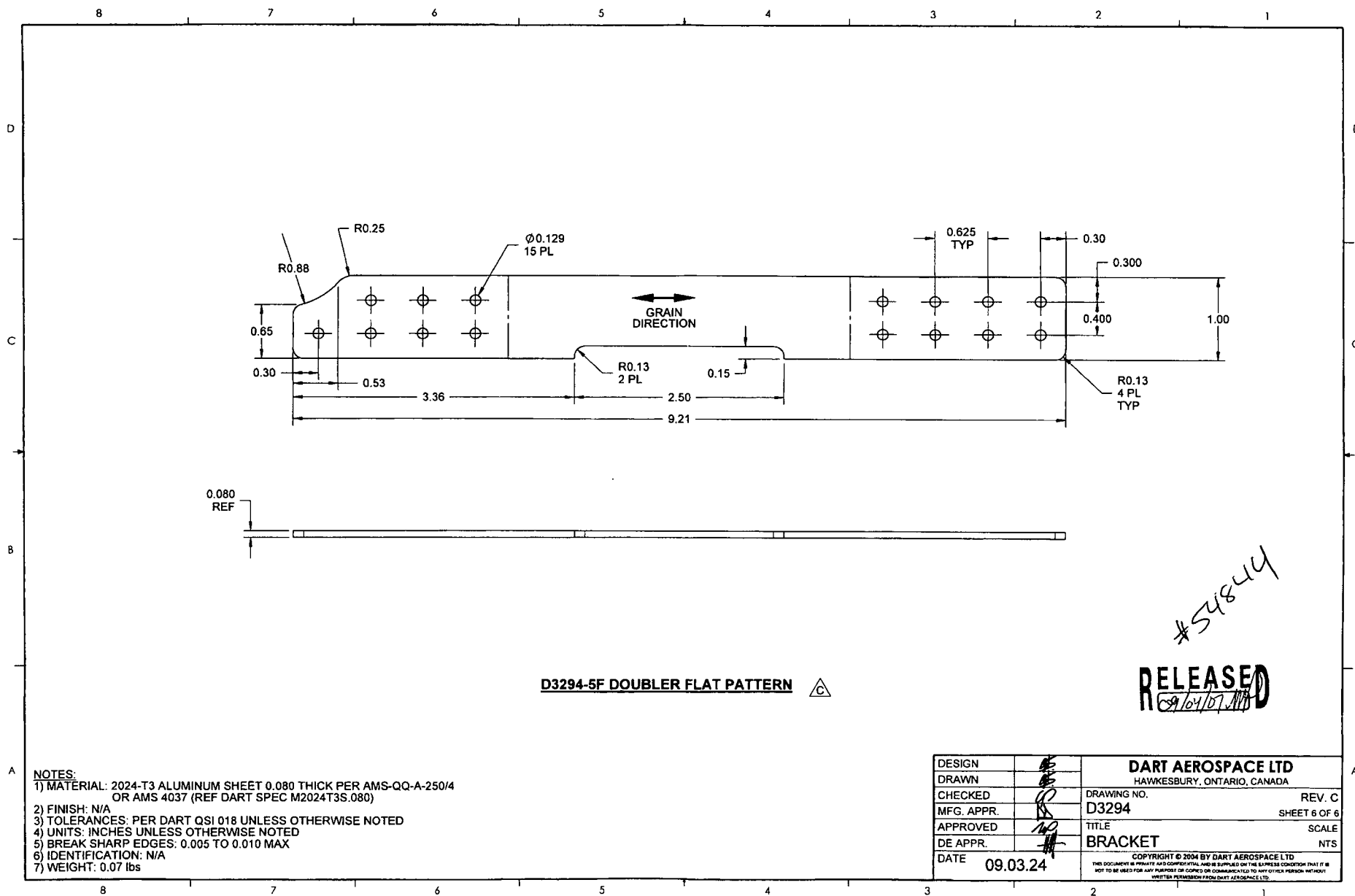
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 09/04/07

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